

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022517**Date Inspected:** 12-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013AD-070 [4394B I-rib stiffener on Floor Beam (FB) 3193A to Side Panel (SP) 3092E, fillet weld at panel point (PP) 119+1500]. The welder is identified as 205098 and was observed welding in 4F position. ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2114-FCM-1.

Repair welding of weld joint no: Seg3013V-461 [X4445A FB sub assembly to I-rib stiffener on FB3186A, complete joint penetration (CJP) weld at PP119-1500]. The welder is identified as 205098 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair.

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Repair welding was done as per Critical Welding Repair Report (CWR): 2875 Rev-0.

OBG Seg 13CW:

The SMAW process on weld joint no: Seg3015A-001 [Bottom Panel (BP) 3064A to Side Panel (SP) 3098A, CJP weld]. The welder is identified as 045196 and was observed welding in 4G position. ZPMC QC was identified as Wang Xiang Ping. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no: Seg3015A-009 (BP3070A to SP3107A, CJP weld). The welder is identified as 045213 and was observed welding in 4G position. ZPMC QC was identified as Wang Xiang Ping. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Repair welding of weld joint no: Seg3013AD-076 (X4394B I-rib stiffener on FB3193A to SP3092E CJP weld at PP 119+1500). The welder is identified as 020598 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per CWR: 2875 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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